

Form No:	 PE&SD	BHARAT HEAVY ELECTRICALS LIMITED PROJECT ENGINEERING & SYSTEMS DIVISION		PY 52 062	
		TECHNICAL SPECIFICATION		Rev. No. 01	
		MS PIPES IS-1239 (PART-1) SEAMLESS/WELDED		Page 1 of 2	

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1.0 GENERAL

The Mild Steel (MS) Seamless / Welded Pipes supplied according to this specification shall conform to the requirements of latest version of **Indian Standard IS 1239 Part-1 (Specification for Steel Tubes, Tubulars and other Wrought Steel Fittings)** and comply with the following additional requirements.

2.0 MANUFACTURE:

- 2.1 This specification is applicable for both Seamless and Welded Pipes, to be manufactured as per process specified in Indian Standard IS 1239 (Part-1).
- 2.2 The pipes shall be supplied with Plain Ends.

3.0 CHEMICAL COMPOSITION:

Shall be as per the requirements of Indian Standard IS 1239 (Part-1).

4.0 MECHANICAL PROPERTIES:

Shall be as per the requirements of Indian Standard IS 1239 (Part-1).

5.0 DIMENSIONS AND TOLERANCES:

- 5.1 Pipe Size (Nominal Bore - NB) and wall thickness (Light / Medium / Heavy) shall be as specified on BHEL order.
- 5.2 Pipes shall be supplied in single random lengths of 5 to 7 metres, unless otherwise specified. No jointers are permitted.
- 5.3 Unless otherwise specified, Quantity Tolerance shall be as follows depending on the Ordered quantity:
 - 5.3.1 Upto 200m : $\pm 10\%$
 - 5.3.2 Above 200m upto 500m : $\pm 5\%$
 - 5.3.3 Above 500m : $\pm 20\%$
- 5.4 All other Tolerances shall be as per IS 1239 (Part-1).

6.0 DESIGNATION:

A Mild Steel welded pipe of nominal bore NB50 and wall thickness - Heavy supplied according to this standard, shall be designated as:

PIPE (WELDED) MS NB50 HVY IS 1239.

7.0 TESTING REQUIREMENTS:

All the applicable tests as per the requirements of National Standard IS-1239 (Part-1) shall be carried out successfully.

8.0 INSPECTION REQUIREMENTS:

BHEL's representative shall have free access at all times to all parts of the manufacture's works, until the work on the contract of BHEL is being performed. The manufacturer shall offer BHEL's representative all reasonable facilities, without charge, to satisfy the latter that the material is being furnished in accordance with the specification.

Refer Doc	LAYOUTS & PIPING ENGINEERING	PREPARED	CHECKED	APPROVED	DATE
		 G SRIKANTH	 G SRIKANTH	 VVSS SUNDAR	12.03.15

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9.0 TEST CERTIFICATES:

Three copies of test certificates shall be supplied, unless otherwise stated on the order. In addition, the supplier shall ensure to enclose one copy of the test certificate along with their dispatch documents to facilitate quick clearance of the material. The test certificate shall bear the following information:

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BHEL order No:

Supplier's Reference:

Name:

Identification No:

Melt No:

Results of Tests:

- Results of Dimensional inspection.
- Results of Chemical Analysis, Mechanical Tests, Hydraulic & NDE tests.

10.0 PACKING AND MARKING:

Packing and Marking shall be as per BHEL Corporate Standard **AA0490001**.

11.0 REJECTION AND REPLACEMENT:

If each length of pipe does not comply with the requirements of this specification during receipt inspection at BHEL/Project site or if any defect is found during further processing of pipes, BHEL reserves the right to reject the whole consignment and the supplier shall replace the material free of cost. The rejected material shall be taken back by the supplier after fulfilling the commercial terms and conditions.

RECORD OF REVISIONS:

Rev No	Date	Revision Detail	Revised by	Approved by
00	12.03.2015	FIRST ISSUE	-	-
01	03.12.2016	Quantity Tolerance updated and Generally revised	 G KALYAN	 SRIKANTH G